

Thursday, May 19, 2016 2:56:40 PM

146595

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 6/14/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/24/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: MAY 24 2016 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

NOV 02 2016

DAS
27
9-80

DAS
21
9-8

16-10-20

DAS
6
9-8

OCT 19 2010

DAS
28
0-80

DA
27
9-8

NOV 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 146595

Thursday, May 19, 2016 2:56:40 PM

146595

Page 2

Item ID: D206-797-211

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 6/14/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-797-211
Location: FG034DAS
27
9-89DAS
28
9-89

NOV 02 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

DAS
21
9-89

NOV 02 2016

DAS
21
9-89

NOV 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Thursday, May 19, 2016 2:56:39 PM

146595

D206-797-211

Start Date: 6/14/2016**Required Date:** 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.10 as per IIN rev.A DD verf:JLM IPP Rev:B
11.04.18 MS24694-10 TO MS24694-S10 DD verf:JLM IPP Rev:C 11.04.19
added(1) D4293-1(was missing) DD verf:JLM IPP Rev:D 11.09.12 @ chg
002 DD verf:EC

[illegible]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>					Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																														
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OTHER : _____																																																																			

Picklist Print

Thursday, May 19, 2016 2:56:39 PM

Page 2

Work Order ID: 146595

146595

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 6/14/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D4293-1 Manufactured No

110 Each 12.0000 2 2

D4293-1

Fitting

**

OCT 19 2016

DAS 28
6 9-89
9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

st533

12

116905

4

122955

8

D4314-1 Manufactured No

110 Each 26.0000 4 4

D4314-1

Shim

**

OCT 19 2016

DAS 28
6 9-89
9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST091

26

120515

6

123102

20

D4314-3 Manufactured No

110 Each 43.0000 4 4

D4314-3

Shim

**

OCT 19 2016

DAS 28
6 9-89
9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST091

43

113351

14

119651

9

123115

20

AN6-17A Purchased No

110 Each 18.0000 2 2

AN6-17A

Bolt

**

OCT 19 2016

DAS 28
6 9-89
9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST334

18

m128403

3

m130466

15

Thursday, May 19, 2016 2:56:39 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐											
Date: CAC 23-2	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval									
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		OTHER : _____											

Picklist Print

Thursday, May 19, 2016 2:56:39 PM

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Work Order ID: 146595

146595

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 6/14/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

AN6-20A Purchased No

110 Each 33.0000 2 2

AN6-20A
BOLT

**

OCT 1 9 2016

DAS 6 9-89
DAS 28 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
over005	30	
M133932	30	
ST334	3	
M128936	3	

2

NAS1149D0663J Purchased No

110 Each 806.0000 8 8

NAS1149D0663J
Washer

**

135464

OCT 1 9 2016

DAS 6 9-89
DAS 28 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
ST260	227	
M131618	227	
ST263	524	
M133134	89	
M133769	12	
M133812	6	
M134634	417	
ST269	55	
M126334	55	

MS21042L6 Purchased No

110 Each 191.0000 4 4

MS21042L6
Nut

**

M135058

OCT 1 9 2016

DAS 6 9-89
DAS 28 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
ST303	191	
m133938	6	
m134055	5	
m134509	30	
m134567	50	
m134676	100	

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : 24/02/2020	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 146595

146595

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 6/14/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS27151-19

Purchased

No

110

Each

67.0000

4

4

MS27151-19

NUT

**

OCT 19 2016

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST275

67

m132285

20

m132399

47

MS24694-S10

Purchased

No

110

Each

136.0000

4

4

MS24694-S10

SCREW

**

OCT 19 2016

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST284

136

117442

36

120986

100

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Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : BAC 2 28-2	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
BAC 2 28-2				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

5.0 PARTS LIST

Qty -021	Qty -022	Qty -023	Qty -024	Qty -211	Part Number	Description
X					D206-797-021	QUICK RELEASE HELI-UTILITY-BASKET
	X				D206-797-022	QUICK RELEASE HELI-UTILITY-BASKET
		X			D206-797-023	QUICK RELEASE HELI-UTILITY-BASKET
			X		D206-797-024	QUICK RELEASE HELI-UTILITY-BASKET
1	1	1	1	X	D206-797-211	QUICK RELEASE BASKET MOUNTING KIT
1					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
	1				D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
		1			D4272-013	BASKET ASSY, LIGHT WEIGHT LID, LH
			1		D4272-014	BASKET ASSY, LIGHT WEIGHT LID, RH
				1	D4271-011	BEAM ASSY, FWD
				1	D4271-013	BEAM ASSY, AFT
				2	D4292-1	FITTING
				2	D4293-1	FITTING
				4	D4314-1	SHIM
				4	D4314-3	SHIM
				1	D4713-1	SPACER
				2	AN6-17A	BOLT
				2	AN6-20A	BOLT
				8	NAS1149D0663J	WASHER (OR AN960JD616)
				4	MS21042L6	NUT (OR MS21042-6)
				4	MS27151-19	NUT
				4	MS24694-10	SCREW
				1	MS3367-5-0	TIE WRAP

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Date: 15.04.14